D3925-3 Work Order ID 108905 \*108905\* Page 1 B 108905 October-29-13 10:15:29 AM Accept \*N900040100\* Item ID: D3925-3 Setup Start Revision ID: Seatbelt Reel Bracket Item Name: Start Date: 10/24/13 Start Qty: 2.00 **Cust Item ID:** Required Date: 10/29/13 Rea'd Oty: 2.00 **Customer:** Reference: Run Process Plan: MCJ Date: 13-10-29 Tooling: Date: Approvals: Stop Date: SPC (Y/N): QC: Date: Set Up/ Sequence ID/ **Operation** Tool # Plan Reject Reject Tool ID Accept Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** A D'3925 100 0.00 FLOW WATER JET \*100\* 2 0 Im 13-11-23 0.00 Waterjet Memo FLOW CNC Waterjet 1-Cut as per Dwg Dwg Rev: A 6061.125. Prog Rev: 2-Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 110 \*110\* 2 。\_\_\_\_ 0.00 Memo Quality Control DAS 27 OC8- Inspect parts - second check 120 9-89 \*120\* Memo

Quality Control

DQA:		Date	e:									
QA Closed:		Date	a:		WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT	TE W	ork Order up	ndate only	AEROSPACE
-		:										
Work Orde	er:				DISPOSITION			AC	GAINST DE	PARTMENT	/PROCESS	
				_	Rework	]		Skid-tube Cro	osstube		Water Jet	Engineering
Part N	No				Scrap		!	Machining Sm	nall Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming Fi	inishing	Rec/Stor	e/Packaging	Other
NCR I	No				Suspected Unapproved	Large Fab Composite					Supplier	
Root				Desc	ription of work order update		nitial	Action		Sign &		
Cause	Da	te Step	Qty		or non-conformance	1	ief Eng		1	Date	Verification	QC Inspector
Design									·			
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup												
Process												
Supplier												
Training								:				
Transport												
Unapproved												
						FAI	ULT CAT	<b>TEGORY</b>				
Landii	ng Gear			_	General					_		
	Bend	ng			Bend		Folio/P	Program		Outside Dim	ensions	Pressure/Forced
	Centr	e Not Conc	entric	L	BOM/Route		Grain			Over/Under	tolerance	Set-up
	Crack			L	Broken/Damage/Defect		Hardwa	ire		Part Incorrec	:t	Temperature/Cure
	Crimp	/Kink/Ripp	le/Wave		Burrs		Inspecti	ion Incomplete/Unqualifi	ied	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/Unclear	r	Part Moved		Wrong Stock Pulled
	Crush	_			Countersink		Misalig	ned/off center		Positioned W	/rong	-
	Heat	Treat			Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Other
		ction Strip	in Tube		Drawing		Misread	t		-	<b></b>	
	Mark	s/Chatter			Drill Holes		Off-set					
	Turni	ng Sequenc	e		Finish		Out of 0	Calibration				
	Wave	/Twist in T	ube		Fit/Function		Out of 9	Seguence				

Page 2

October-29-13 10:15:29 AM

Item ID:
Revision ID:
Item Name:
Start Date:

D3925-3

Seatbelt Reel Bracket

Start Qty: 2.00 10/24/13

Req'd Qty: 2.00

Accept \*N900040100\*

Setup Start

**Cust Item ID: Customer:** 

Tool ID

Reference:

Approvais:	Process i
	QC:
Sequence ID/ Work Center	ID
130	
*130*	
Brake NC	

Required Date: 10/29/13

Date: Operation Description Form as per dwg

NC BRAKE

Date:\_\_\_\_\_ Tooling:

SPC (Y/N):

Set Up/

Date: Date:

Tool # Plan

Code

Run

Reject

Stop

Insp.

130	
*130*	
Brake NC	
Brake NC	
ž	

Memo

0.00 0.00

**Run Hours** 

DAS 30 9-89 Qty Qty Number Stamp

Reject

\*140\* QC

Quality Control

Memo

0.00

DAS

Accept

Chemical Conversion Coat per QSI005 4.1

QC5- Inspect part completeness to step on W/O

0.00

\*150\* HandFinish

Memo

0.00

a 26/3-11-28

Hand Finishing

DQA:	WORK ORDER NON-CONFORMANCE / UPDATE														
QA Closed:			Date:			WORK ORDER NON-	-C(	JNFOI	RIVIANCE / U		Wo	ork Order up	odate only		AEROSPACE
Work Orde	∍r·					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
Part No						Rework Scrap Use-as-is Suspected Unapproved	Scrap Machining Small Fab Use-as-is Thermoforming Finishing			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other		
Root					Desc	ription of work order update		nitial	Act	tion	1	Sign &		_	
Cause	D	ate	Step	Qty		or non-conformance	1	ief Eng		ription		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
							FAI	ULT CAT	EGORY	-					
Landii	ng Gear				_	General		1 .		r		İ		<b></b>	
	Crac Crim Cuff Crus Heat Insp Mar Turn	tre Noticks hp/Kinks shing t Treat ection ks/Cha	Strip in itter quence	/Wave Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/Ur ions Incomplete/U ned/off center led	· ·		Outside Dime Over/Under Part Incorrect Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Wav	e/Twis	st in Tub	e	1	Fit/Function		Out of S	equence		•				

Work Ord October-29-13				*1089	305*						Page
Item ID: Revision ID:	D3925-3			Accept	*N900	040	100	)* s	etup Star	I VI	S1*
Item Name:	Seatbelt Ree	l Bracket							Stop	, <b>*N</b>	S2*
Start Date: Required Date Reference:	10/24/13 :: 10/29/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:					
Approvals:	Drocess Di	lan:	Date:	Tooling:	n:	ate:		F	Run Stai	* *N	R1*
Approvais.				_		ate:			Sto	*N	R2*
Sequence ID/ Work Center 1 160 *160* QC Quality Control	ID	Operation Description QC7-Inspect Chemical (	Conversion Coat	Set Up/ Run Hours 0.00 27 9-89 0.00   3   11   3	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*170* Packaging Packaging		Identify as per dwg & S  Memo	tock Location	0.00				2x			. 13-1

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

\*1'20\* QC

Quality Control

13-11-28 DAS 26 9-89

Rm 13/12/02. NWF 13-11-29

DQA:		_ Date:											1	<b>AAA</b> RT
QA Closed:		Date:			WORK ORDER NON	I-C(	ONFO	RMANCE / UI	PDATE	Wo	ork Order up	odate only	<del></del>	AEROSPACE
Work Orde	er:				DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part N				<del></del>	Rework Scrap Use-as-is		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing				Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other
NCR No.				Suspected Unapproved			Large Fab	Composite	-		Supplier			
Root				Desc	ription of work order update		Initial	Act	ion		Sign &		Т	
Cause	Date	Step	Qty		or non-conformance	Cr	nief Eng	Descr	iption		Date	Verification	,	QC Inspector
Design Doc/Data														•
Equip/Tooling Handling/Pre														
Material														
Operator														
Offset/Setup	-													
Process	-													
Supplier	7									į				
Training														
Transport														
Unapproved													ŀ	
		•	11			FA	ULT CA	regory		I				
Landir	ng Gear				General				<del></del>					
	Bending				Bend		Folio/F	rogram		$\Box$	Outside Dim	ensions	$\neg$ <sub>P</sub>	ressure/Forced
	Centre N	lot Concer	ntric		BOM/Route		Grain			П	Over/Under	tolerance	_	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		П	Part Incorrec	rt F	_	emperature/Cure
	Crimp/Ki	ink/Ripple	/Wave		Burrs		Inspect	ion Incompléte/Un	qualified	П	Part Lost/Mis	ssing	_	Veld
	Cuffs				Contamination		Instruct	ions Incomplete/U	Inclear	П	Part Moved	· ·	$\neg$ <sub>v</sub>	Vrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center			Positioned W	/rong		· ·
	Heat Tre	at			Cut Too Short		Mislabe	eled			Power Loss/S	Surge	$\neg c$	Other
		on Strip in	Tube		Drawing		Misread	d	•			_		
	Marks/C	hatter			Drill Holes		Off-set			-				
		Sequence			Finish		Out of (	Calibration		•				
	Wave/Tu	wist in Tub	oe .	[ ]	Fit/Function		Out of	Seguence		•		<del></del>		

Page 1

October-29-13 10:15:29 AM

Work Order ID:

108905

Parent Item:

D3925-3

Parent Item Name:

Seatbelt Reel Bracket

**Start Date:** 10/24/13

Required Date: 10/29/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A 13.07.04 PER DWG REV.A DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No	<del></del>			sf	155.0000		0,088421 0.25		JM1	3-11-23

DQA:			Date:											7	
						<b>WORK ORDER NON</b>	-C	ONFO	RMANCE / L	JPDATE					
QA Closed:			Date:								Wo	rk Order up	odate only		72.00.202
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
<u> </u>	•	· <u>.</u>		•	_	Rework	]		Skid-tube	Crosstube	П		Water Jet		Engineering
Part N	۷o.					Scrap	1		Machining	Small Fab	П	Pro	d. Eng. Coor.		Quality
1			•			Use-as-is	]	Therr	noforming	Finishing		Rec/Stor	re/Packaging		Other
NCR I	No.				<del></del>	Suspected Unapproved	]		Large Fab	Composite			Supplier		
Root					Desc	ription of work order update		Initial	Ac	ction	Т	Sign &			
Cause		Date	Step	Qty		or non-conformance	Cł	nief Eng	1	cription		Date	Verificatio	n	QC Inspector
Design															
Doc/Data											İ			ĺ	
Equip/Tooling													:		
Handling/Pre			-												
Material	Ш					•								ļ	. •
Operator	Ш														,
Offset/Setup						,									
Process															
Supplier															
Training															
Transport									1						
Unapproved															
							FA	ULT CA	TEGORY						
Landi						General		-							
	Ш	Bending			<u> </u>	Bend		Folio/F	Program		Щ°	Dutside Dim	ensions		Pressure/Forced
	Ш	Centre No	ot Concer	ntric	<u> </u>	BOM/Route		Grain			$\square$	Over/Under	tolerance		Set-up
	$\vdash$	Cracks			<u> </u>	Broken/Damage/Defect	L	Hardwa	ire		L	Part Incorred	t		Temperature/Cure
	-	Crimp/Kir	nk/Ripple	/Wave	ļ	Burrs		Inspect	ion Incomplete/L	Inqualified	F	Part Lost/Mi	ssing		Weld
	$\vdash$	Cuffs			_	Contamination	L	Instruct	tions Incomplete	/Unclear	L F	Part Moved			Wrong Stock Pulled
	Crushing		<u> </u>	Countersink		Misalig	gned/off center			ositioned <b>V</b>	Vrong .				
	Heat Treat			<u> </u>	Cut Too Short	L	Mislabe	eled	ĺ	LJ F	ower Loss/	Surge		Other	
	$\overline{}$	Inspection	· · · · · · · · · · · · · · · · · · ·	Tube		Drawing		Misread	t		_				
		Marks/Ch				Drill Holes	L	Off-set			_				
	Ш	Turning S	•			Finish	L	Out of 0	Calibration		_				
	Wave/Twist in Tube				Fit/Function	_	Out of S	Sequence		-					

DART AEROSPACE LTD	Work Order:	118905
Description: Seathert Real Bradet.	Part Number:	03925-3
Inspection Dwg: D39as Rev: A		Page 1 of 1

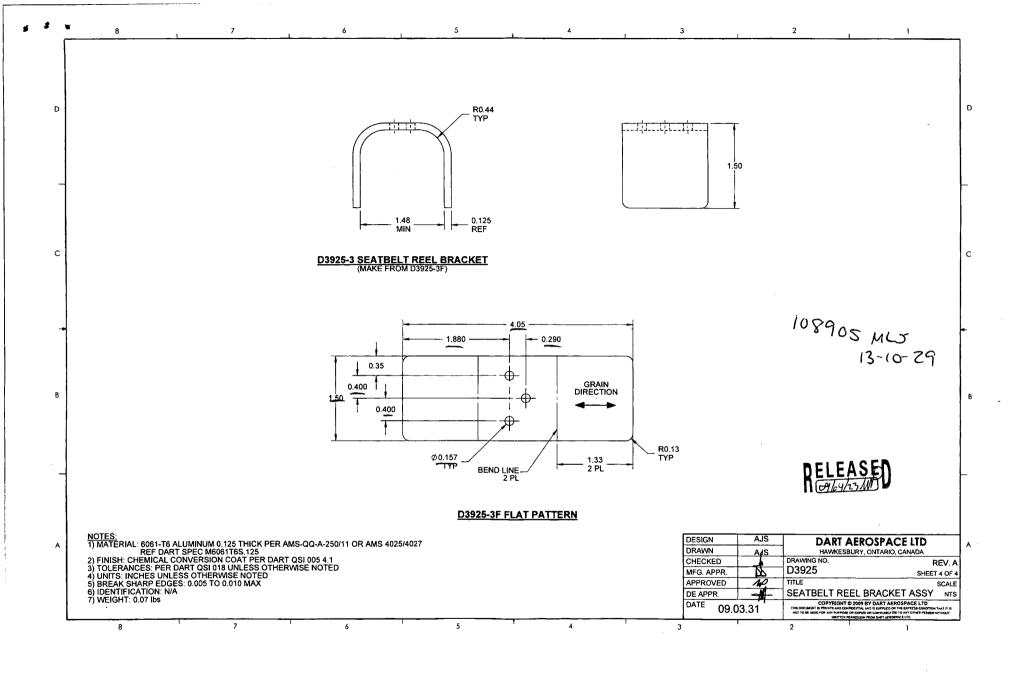
## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.157"	10.005-0001	0.158"			U	Jhnor
1.880"	41-0:4010	1.882			υ	
0.290	41-0.010	0.290"			V	
0.400"		0-402"			U	
0.400"	**	0.401"	_		U	
いっちい"	41-0:030	1.515"			V	
0.35°	l l	0.353"			U	
4.05"	( ·	4.062"	_		V	
	41-0.0104	0.121	_		U	
	DERECTION		<u> </u>		N/A.	
		,				
		,				
					_	
			,			

		DAS		
Measured by: Jim	Audited by:	27	Preliminary Approval:	
Date: 13-11-23	Date:	13 11 25	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ .	

\$ 10.04.15



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